

Work Order ID 73128

Friday, August 26, 2011 6:32:29 AM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 8/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *CMF*Date: *11-08-29*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

N/A *[Signature]*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Item ID: D206-642-541

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch: M112860

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP

11-9-14

DL 11/09/15

BE 11/09/15

BE 11/09/15

DL 11/09/15

| W/O: | | WORK ORDER CHANGES | | | | | |
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Start Date: 8/26/2011 Start Qty: 1.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

114



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sulorist

116



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

Sulorist

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

*JW**11-09-19*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D206-642-541

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Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 8/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | | | | | | |
| | | | | | | | | | |
| 150 | Skidtubes | 0.00 | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 | | | | | | | | |
| | 2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube | | | | | | | | |
| | 3-Bond web in place as per Dwg D3274 & QSI 015. | | | | | | | | |
| | A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> 118393 <input type="checkbox"/> | | | | | | | | |
| | Sikaflex expire date: <input type="checkbox"/> 12/04/05 | | | | | | | | |
| | Start: <input type="checkbox"/> 11/09/20 <input type="checkbox"/> Time: <input type="checkbox"/> 3:20 pm | | | | | | | | |
| | Finish: <input type="checkbox"/> <input type="checkbox"/> Time: <input type="checkbox"/> | | | | | | | | |
| | (Adhere for 12 hours) | | | | | | | | |

11-9-20

11/09/20

OK 11/09/20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 8/26/2011 Start Qty: 1.00

Required Date: 9/9/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

170



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

Tw

11-09-22

Tw

11-09-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 8/26/2011 Start Qty: 1.00

Required Date: 9/9/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

190

Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R ☐ Aluminum Rod 112860

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

11-09-26

11/09/27

11-9-27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 73128

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Item ID: D206-642-541

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Setup Start



Revision ID:

Stop



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Start Date: 8/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Sulcoloy

Quality Control

Pro →

210

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Sulcoloy

Quality Control

220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

NDM 11/10/04

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: D266-642-34 PAR #: N/A Fault Category: Landing Gear/Skid NCR: Yes No QA: 12 Date: 11.10.14
11-889 Resolution: Re work Disposition: Re work QA: N/C Closed Date: 11/10/14

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|-----------------------------|--|---------------------------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 11/09/27 | #190 | Found At inspection that the SADDLES do not align. cannot get the Bushing on on hole. the 17th hole from aft. (Last Pair saddle hole). | CP 11.09.27 | → Drill out + Ream D2649 (17th hole). → Re weld new D2649 B 33857 Qty +1 | CP 11-10-3 BE 11/10/03 | S 11/10/04 | CP 11.09.27 | S 11/09/27 |
| | | R.C. Pulled when welding process | CP 11.09.27 | A/R M117887 As per 052004 → Re counter bore + Grin → Grind welds flush + Re counter bore as per Day + Deburr | CP 11-10-3 | S 11/10/04 | CP 11.09.27 | S 11/09/27 |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 73128

Friday, August 26, 2011 6:32:29 AM

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Item ID: D206-642-541

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Stop

Item Name: Replacement Skidtube

Start Date: 8/26/2011 Start Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----|--|------|--|--|--|--|--|--|--|
| 230 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
|-----|--|------|--|--|--|--|--|--|--|


Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00
320
1:30
JF

1 X J M-L 11/10/04

| | | | | | | | | | |
|-----|--------------------------|------|--|--|--|--|--|--|--|
| 240 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
|-----|--------------------------|------|--|--|--|--|--|--|--|



QC

Quality Control

Memo

0.00

1 BR 11-10-5

| | | | | | | | | | |
|-----|---------------|------|--|--|--|--|--|--|--|
| 250 | HandFinishing | 0.00 | | | | | | | |
|-----|---------------|------|--|--|--|--|--|--|--|



HandFinish

Hand Finishing

Memo

0.00

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/R ☐ N/A ☐ LPS-3 ☐ 114546

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/R ☐ ☐ Sikaflex-291 ☐ 118393 ☐

Sikaflex expire date: ☐ 125

1 BR 11-10-5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/11/10/05

FL

Quality Control

Inspect Nut Plate & Inserts

270

HAND FINISHING RESOURCE #1

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☐ 118393 ☐Sikaflex expire date: ☐ 12-5 ☐

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: 10/17

5-Install Aft Cap and seal with Sikaflex Clean excess adhesive.

A/R ☐ Sikaflex-291 ☐ 118393 ☐Sikaflex expire date: ☐ 12-5 ☐

PROC 400 M 114596

1 BL 11-9-5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Required Date: 9/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Sulidos



Pto →

Quality Control

290

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

PP 73124

11/10/11

Packaging

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/10/11

Quality Control

11-10-07

| W/O: 73128 | | WORK ORDER CHANGES | | | | | |
|------------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: D2646 PAR #: N/A Fault Category: Finishing NCR: Yes No DQA: N/A Date: 11.10.14
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 11/10/14

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) 13.58 | | | | | | |
|----------|------|--|-----------------------------|---|----------------|---------------------------|--------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 11/10/05 | #270 | when installing Aft CAD to insert Stripes when the insert was removed to hole was oversized R.C. Process | S 05/04/2 11/10/05 | hole measure to be 0.340" should be 0.297" + insert doesn't fit. Scrap + Destroy Qty = 1 D2646 B 11070 | 11/10/05 | S 11/10/05 | S 05/04/2 11/10/05 | S 11/10/05 |
| | | | | | | | | |
| | | | | | | | | |

*NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 6:32:24 AM

Page 1

Work Order ID: 73128

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube


Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2600-1-190  Extrusion Round 3" 206 | | Manufactured | No | | | 110 | Each | 81.4000 | 1 | 1 | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| HALL | 81.4 | |
| 59874 | 22.4 | |
| 69622 | 59 | |

| | | | | | | | | | | | | | |
|--|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D3285-1  Cap | | Manufactured | No | | | 110 | Each | 92.0000 | 1 | 1 | | | |
|--|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG002 | 92 | |
| 52511 | 45 | |
| 52647 | 47 | |

| | | | | | | | | | | | | | |
|---|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|
| D3282-041  Float Web (206L/407) | | Manufactured | No | | | 150 | Each | 2.0000 | 1 | 1 | | | |
|---|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 2 | |
| 69714 | 2 | |

① DP 11-9-14

BE 11/09/15

Wh 11/09/20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 73128

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

46.0000

12

12



Cross Bolt Spacer



11.09.26

Location

Loc Qty

Loc Code

| | | |
|-------|---------------|----|
| LG | <u>373390</u> | 34 |
| | 68224 | 2 |
| | 71355 | 2 |
| | 72704 | 30 |
| LG001 | | 12 |
| | 65317 | 1 |
| | 68507 | 11 |

12

D3275-1

Manufactured No

190

Each

280.0000

12

12



Crossbolt Spacer



11.09.26

Location

Loc Qty

Loc Code

| | | |
|-------|--------------|-----|
| LG | <u>72123</u> | 161 |
| | | 161 |
| LG002 | | 119 |
| | 66930 | 106 |
| | 68946 | 13 |

12

CR3212-4-03

Purchased No

250

Each

1,158.000

2

2



Cherry Rivet



BR 11-10-5.

Location

Loc Qty

Loc Code

| | | |
|-------|----------|------|
| FP-B | | 2 |
| | 110139 | 2 |
| ST311 | | 1156 |
| | 114859 ✓ | 1156 |

2

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Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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*NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 73128

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3415-041

Manufactured No

250

Each

50.0000

1

1



Nut Plate



BR 11-10-5

Location

Loc Qty

Loc Code

ST053

50

33842

6

67605 ✓

44

CCR264SS3-3

Purchased No

250

Each

459.0000

2

2



Cherry Rivet



BR 11-10-5

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

457

117086

31

117849 ✓

426

ALS4-1032-130

Purchased No

250

Each

1,416.000

78

78



Insert



BR 11-10-5

Location

Loc Qty

Loc Code

ST281

370

118386

370

ST282

1046

117717 ✓

54

118237

736

118312

256

ALS4-1032-130

118966

34

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Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 6:32:25 AM

Page 4

Work Order ID: 73128

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-15
Gasket

Manufactured No

270 Each

22.0000

1 1

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP011 | 22 | |
| 71586 ✓ | 13 | |
| 72881 | 9 | |



BL 11-10-5.

D3536-23
Gasket

Manufactured No

270 Each

18.0000

1 1

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP011 | 18 | |
| 43406 | 1 | |
| 69902 | 5 | |
| 71579 ✓ | 12 | |



BL 11-10-5.

D3536-35
Gasket

Manufactured No

270 Each

23.0000

1 1

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP012 | 23 | |
| 71587 | 13 | |
| 72882 | 10 | |



BL 11-10-5.

D3536-39
Gasket

Manufactured No

270 Each

20.0000

1 1

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP015 | 20 | |
| 69760 ✓ | 20 | |



BL 11-10-5.

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Shop Packet Print

Page 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 73128

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 8/26/2011



Required Date: 9/9/2011

Start Qty: 1.00



Required Qty: 1.00

D3535-15 Manufactured No 270 Each 9.0000 1 1
  *BR 11-10-5.*
Wearshoe



| Location | Loc Qty | Loc Code |
|----------------------|---------|----------|
| FP018 <i>73006</i> ✓ | 9 | |
| 69931 | 9 | |

D3535-35 Manufactured No 270 Each 12.0000 1 1
  *BR 11-10-5.*
Wearshoe

| Location | Loc Qty | Loc Code |
|----------------------|---------|----------|
| FP018 <i>73311</i> ✓ | 12 | |
| 65926 | 1 | |
| 67598 | 1 | |
| 70815 | 10 | |

D3535-39 Manufactured No 270 Each 19.0000 1 1
  *BR 11-10-5.*
Wearshoe

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP018 | 19 | |
| 69759 | 6 | |
| 72159 | 13 | |

D3535-23 Manufactured No 270 Each 18.0000 1 1
  *BR 11-10-5.*
Wearshoe

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP021 | 18 | |
| 70818 | 8 | |
| 71581 | 10 | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 6:32:25 AM

Page 6

Work Order ID: 73128

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-3

Manufactured No

270

Each

11.0000

1

1



Wearpad



BR 11-10-5.

Location

Loc Qty

Loc Code

FP

5

70481 ✓

5

FP017

6

35697

1

72686

5

1

D3537-1

Manufactured No

270

Each

66.0000

9

9



Wearpad



BR 11-10-5.

Location

Loc Qty

Loc Code

FP001

9

69530

9

FP016

50

68944

0

70687

50

FP017

7

69817

5

70686

2

9

AN960C10L

NAS1149C0332

✓ Purchased

No

270

Each

0.0000

80

80



washer

118354



80.

BR 11-10-5.

AN960C416

NAS1149C0463

✓ Purchased

No

270

Each

0.0000

1

1



washer

117735



1

BR 11-10-5.

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 6:32:25 AM

Page 7

Work Order ID: 73128

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

1,180.000

2

2



Phenolic Washer



BL 11-10-5

Location

Loc Qty

Loc Code

ST074

1178

64177

182

66821 ✓

496

72229

500

ST077

2

52505

2

2

AN3C4A

Purchased

No

270

Each

2,125.000

80

80



BOLT



BL 11-10-5

Location

Loc Qty

Loc Code

ST350

2125

117313

2

117688

36

117795

1

117872

22

118012

20

118112

40

118451 ✓

1000

118628

1004

80

AN4C5A

Purchased

No

270

Each

487.0000

1

1



BOLT



BL 11-10-5

Location

Loc Qty

Loc Code

FP-B

98

112243 ✓

98

ST345

389

112243

389

1

Friday, August 26, 2011 6:32:25 AM

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 6:32:25 AM

Work Order ID: 73128



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

93.0000

1

1



Aft Cap



BR 11-10-5.

Location

Loc Qty

Loc Code

FP004

46

68280

46

FP006

5

62678

5

FP-4

38

70945

1

71070 ✓

37

fp5

4

71038

4

1

D3413-1

Manufactured No

270

Each

23.0000

1

1



Ring



BR 11-10-5.

Location

Loc Qty

Loc Code

ST420

23

66387

1

70773

22

72137

1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

RELEASED

07.02.12

DEO ATTACHED

| | | | |
|------------------------|-------------------------|--|------------------------|
| DESIGN CP | DRAWN BY PH | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3274 | REV. D SHEET 1 OF 4 |
| DATE 06.12.19 | | TITLE SKIDTUBE ASSEMBLY SCALE NTS | |
| A | 04.03.15 | NEW ISSUE | |
| B | 04.08.09 | MOVE SADDLE HOLE: 42.14 WAS 42.76 | |
| C | 05.03.16 | ADD -043; NEW INSERTS | |
| D | 06.12.19 | NEW INSERTS, SS WEARSHOE + GASKET | |

| Qty -041 | Qty -043 | Part Number | Description |
|-------------|-------------|---------------|---|
| X | | D3274-041 | SKIDTUBE ASSEMBLY |
| | X | D3274-043 | SKIDTUBE ASSEMBLY |
| 1 | 1 | D2600-1-240 | EXTRUSION |
| 1 | 1 | D2646 | AFT CAP |
| 12 | 12 | D2649 | CROSS BOLT SPACER |
| 12 | 37 | D3275-1 | CROSS BOLT SPACER |
| 1 | 1 | D3282-041 | FLOAT WEB |
| 1 | 1 | D3285-1 | CAP |
| 1 | 1 | D3413-1 | RING |
| 1 | 1 | D3415-041 | NUT PLATE |
| 1 | 1 | D3535-15 | WEARSHOE |
| 1 | 1 | D3535-23 | WEARSHOE |
| 1 | 1 | D3535-35 | WEARSHOE |
| 1 | 1 | D3535-39 | WEARSHOE |
| 1 | 1 | D3536-15 | GASKET |
| 1 | 1 | D3536-23 | GASKET |
| 1 | 1 | D3536-35 | GASKET |
| 1 | 1 | D3536-39 | GASKET |
| 9 | 9 | D3537-1 | WEARPAD |
| 1 | 1 | D3537-3 | WEARPAD |
| 78 | 78 | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130) |
| 80 | 80 | AN3C4A | BOLT |
| 1 | 1 | AN4C5A | BOLT |
| 1 | 1 | AN960C416 | WASHER |
| 80 | 80 | AN960C10L | WASHER |
| 2 | 2 | CCR264SS3-3 | RIVET |
| 2 | 2 | CR3212-4-03 | RIVET |
| 2 | 2 | NAS1515H3L | WASHER |

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____




| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

SECRET #



07.02.12

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| | CHECKED  | APPROVED  | DRAWING NO. D3274 | REV. D SHEET 2 OF 4 |
| | DATE 06.12.19 | | TITLE SKIDTUBE ASSEMBLY | SCALE 1:15 |

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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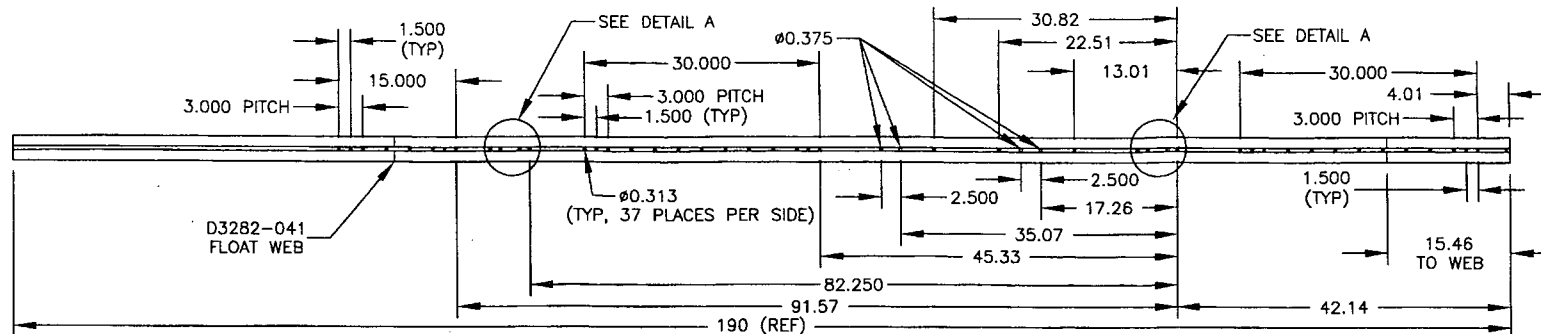
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

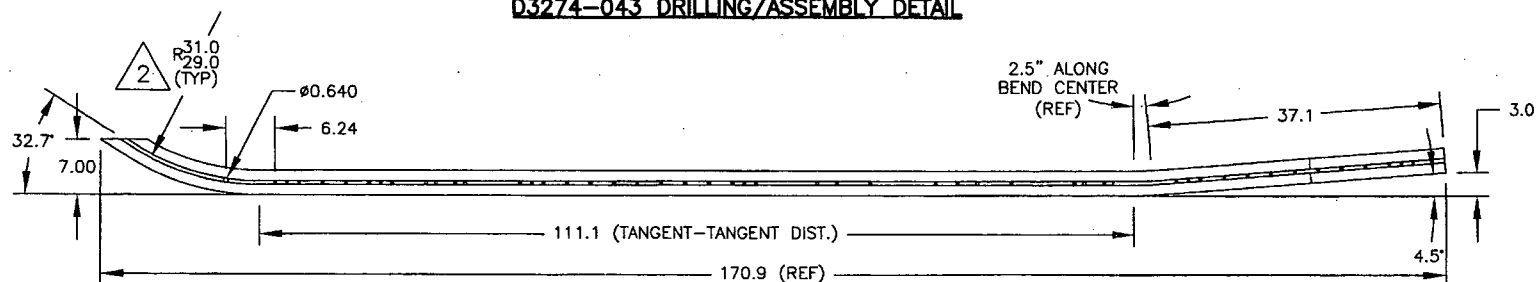
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

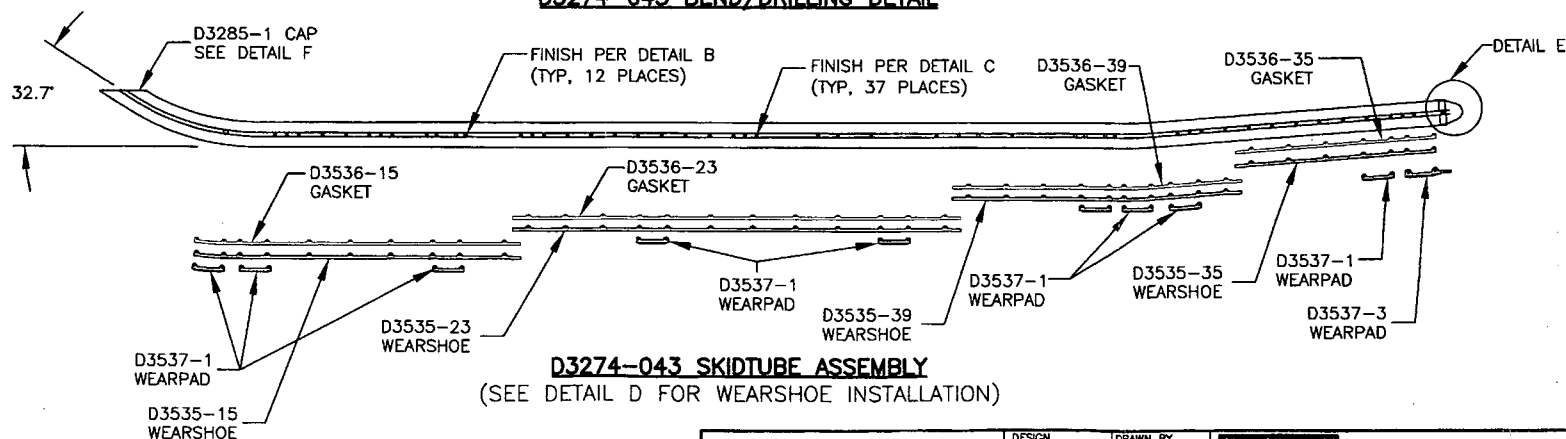
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

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|---------|----------|----------|-------------------|--|--------------|
| DESIGN | CP | DRAWN BY | PH | DART DART AEROSPACE USA, INC. PORT HADLOCK, WA | REV. D |
| CHECKED | H | APPROVED | H | DRAWING NO. D3274 | SHEET 3 OF 4 |
| DATE | 06.12.19 | TITLE | SKIDTUBE ASSEMBLY | SCALE | 1:15 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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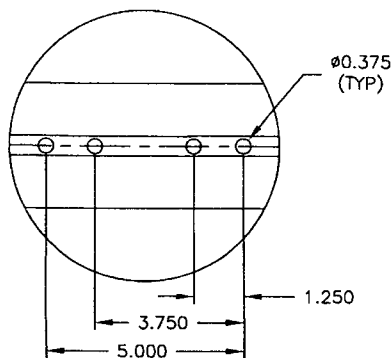
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

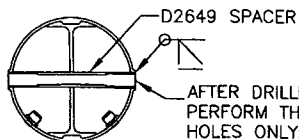
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DETAIL A: DRILL DETAIL

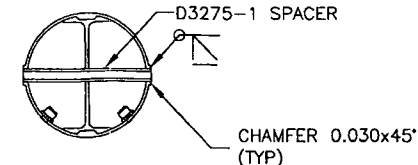


DETAIL B FOR 0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



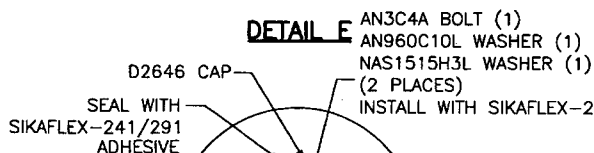
DETAIL D



ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



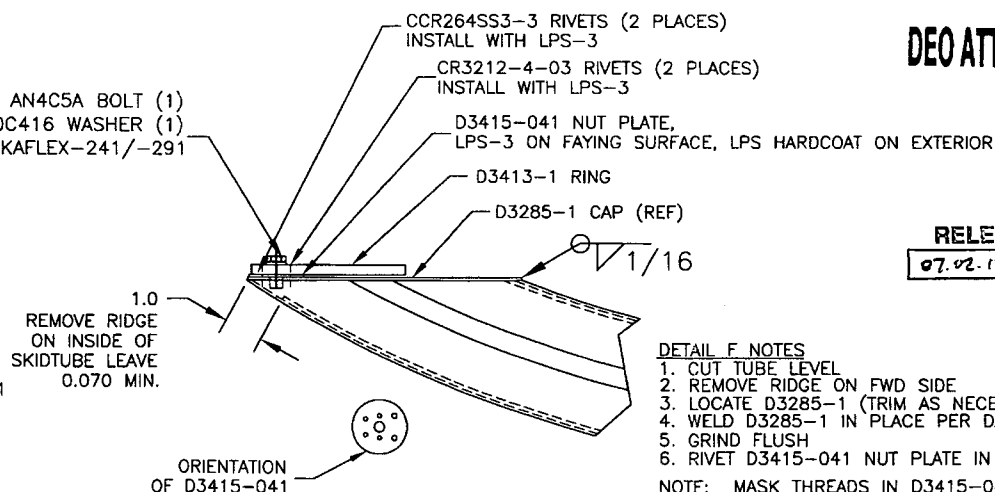
AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

0.400

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DEO ATTACHED

RELEASED
07.02.12

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|---------|----------|----------|-------------------|--|
| DESIGN | CP | DRAWN BY | PH | DART DART AEROSPACE USA, INC. PORT HADLOCK, MA |
| CHECKED | PH | APPROVED | PH | DRAWING NO. D3274 |
| DATE | 06.12.19 | TITLE | SKIDTUBE ASSEMBLY | REV. D SHEET 4 OF 4 SCALE 1:3 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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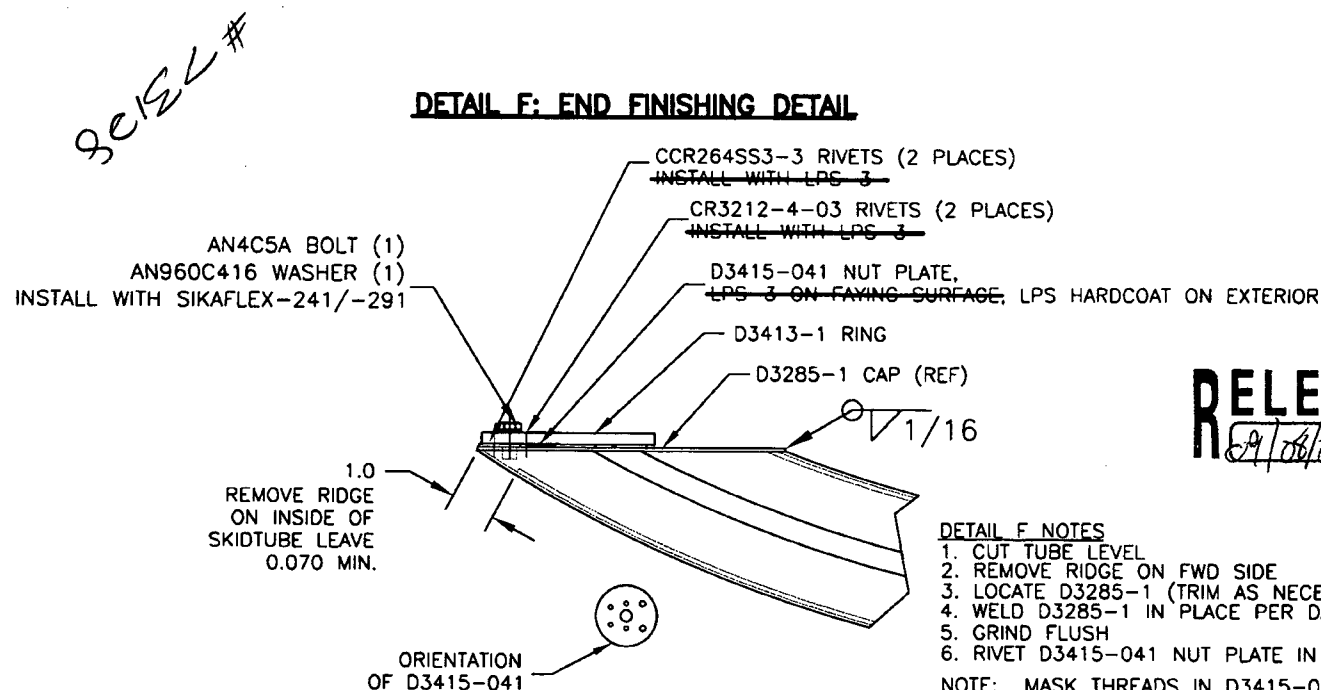
NOTE: Date & initial all entries

| | | | | | | |
|----------------------|----------------------------|-------------------------------|--------------------------------|-----------------------------|---------------------------|--------------|
| DRAWING NO. D3274 | TITLE SKIDTUBE ASSEMBLY | REV. D | DART AEROSPACE USA, INC | D.E.O. NO. D3274-D-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>UP</i> | CHECKED <i>[Signature]</i> | MFG. APPR. <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DE APPR. <i>[Signature]</i> | | |
| DATE 09.06.17 | DATE 09.06.23 | DATE 09/06/23 | DATE 09/06/23 | DATE 09.06.23 | | |

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:



RELEASED
09/06/23

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

NO. 267

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Pat Ewers
Job number: 73212
Part number: A206-642-541
Description: Skirt tube
Welding Process: Tig ☒ Mig ☒
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier David Duval Date of Test Coupon 11.09.26
Welder Pat Ewers Date of Test Coupon 11.09.26

The above named individual is qualified in accordance with AWS D17.1.2001 to weld